

5/12

W/O SPLIT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22466B
<b>Description:</b> Lock Shaft (R44)	<b>Part Number:</b>	D3357-5
<b>Dwg:</b> D3357 Rev. A page 3	<b>Qty:</b>	<del>20</del> 40 11
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.02.16	<del>20</del> 40
2	MC	Turn as per Folio FA505 and Dwg D3357 Material: AISI 303 SS Round Bar 1.00" (M303R1.000) <b>Identify for D3357-5</b>	SA	05.04.06	11
		Batch: M17002			
3	QC2	Inspect parts as they come off the CNC machine <b>Identify as D3357-5</b>	SA	05.04.06	11
4	QC8	Second check	RE	05.04.14	11
5	MC	Deburr	SA	05.04.06	11
6	QC5	Inspect work to Step 5	RE	05.04.14	11
7	ST	Identify and Stock	CL	05/04/14	11
8	AC	Cost / part 15.57	SA	05.04.19	11
9	DC	Close W/O 15.57 Inspect Level 21	HA	05.04.19	11

40  
PTO

Rev	Date	Change	Revised By	Approved
A	05.02.03	New issue	KJ/JLM	

PRELIMINARY ISSUE

M303R1.000  
M17002M303R1.000  
M17002

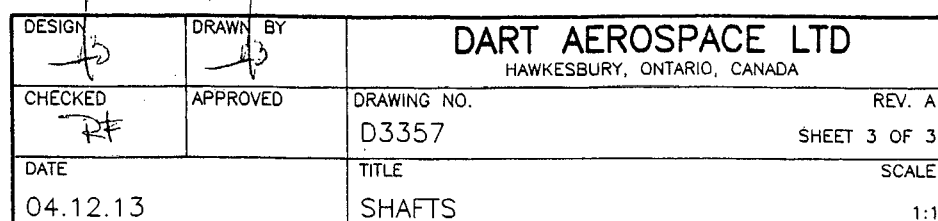
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.04.05	2	UPDATE DWG - ADD (CLASS 2A)	R	05.04.07	N/A	05.04.05	AS pend...

NCR:		WORK ORDER NON-CONFORMANCE (NCR)-						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

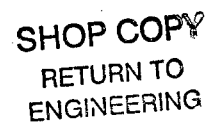
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



# PRELIMINARY ISSUE

$$s = \frac{\pi \cdot 819}{2} = 4.556$$
$$F_{in} = x.616.$$

$$z = 4.760$$


D3357-5 R44 LOCK SHAFT

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 22466

NOTES:

12/05.04.01  
IS ACCEPTABLE TO USC 304 FOR THIS W/O

- 1) MATERIAL: AISI 303 ROUND BAR STAINLESS STEEL  
(REF. DART SPEC. M303R1.000) NO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 15, 2005  
03:37 pm

Work Order No : 0022466  
Project Name : D3357-5  
Project For : WK512  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3357-5  
Description : Lock Shaft R44  
Manufactured : Yes  
Amount Req'd : *40*  
Amount Done : 0  
Start Date :  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DAVE AEROSPACE LTD		Work Order:	22466
Description: Lock Shaft		Part Number:	03357-3
Inspection Date:	Rev:	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.69	+ .030	4.698	✓			
1.163	+ .010	1.163	✓			
.300		.303	✓			
1.110	+ .010	1.109	✓			
1.93	+ .030	1.928	✓			
.125	+ .010	.117	✓			
30°		30°	✓			
.063	+ .010	.073	✓			
Ø.675		Ø.679	✓			
Ø.749	+ .000 - .002	Ø.7485	✓			
Ø.88	+ .030	.894	✓			
						REMOVE SHARP EDGE AS PER DWG.

REMOVE SHARP EDGE  
AS PER DWG.

05.03.06

Measured by: <b>SD</b>	Audited by: <b>gml</b>	Prototype Approval: <b>RT</b>
Date: <b>05.04.06</b>	Date: <b>05/04/06</b>	Date: <b>05.04.06</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	